

Date: Monday, 10/22/2007 4:00:21 PM
 User: Kim Johnston

Process Sheet

44

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	412 GROSS WEIGHT TOWING KIT		
Job Number	35318			Part Number	D412666011		
Estimate Number	12592			Drawing Number	D412-666 REV C		
P.O. Number	N/A			Project Number	N/A		
This Issue	10/22/2007	S.O. No.	N/A	Drawing Revision	C		
Prsht Rev.	NC			Material	N/A		
First Issue	N/A	Type	SMALL /MED FAB	Due Date	10/29/2007	Qty:	5 Um: Each
Previous Run	33583						
Written By							
Checked & Approved By	<i>HD 07.10.23</i>						
Comment	Est Rev:B	Added GHG 002	NG 02-03-06				
	Est Rev:C	As per Rev C	JLM 07-09-07	Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		<i>J</i> CHG 004 <i>K8 07.10.05</i>
2.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>J</i> <i>K8 07.10.05</i>
3.0	D2888	Lug
		<i>J</i> <i>K8</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Lug Batch: <i>B33890</i>
4.0	AN615A	Bolt
		<i>J</i> <i>K8</i>
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bolt Batch: <i>M102832</i>
5.0	AN645A	Bolt
		<i>J</i> <i>K8</i>
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bolt Batch: <i>M105055 8x</i>
		<i>J</i> <i>K8</i>
		<i>M105350 12x</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 35318

Part Number: D412666011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: M105125

7.0 MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Batch: M104374

8.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location: _____

PPP Rev: E

7-11-12 5P 5X

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7-11-12 5P 5X
10-11-13

Job Completion



7-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)



3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N·m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

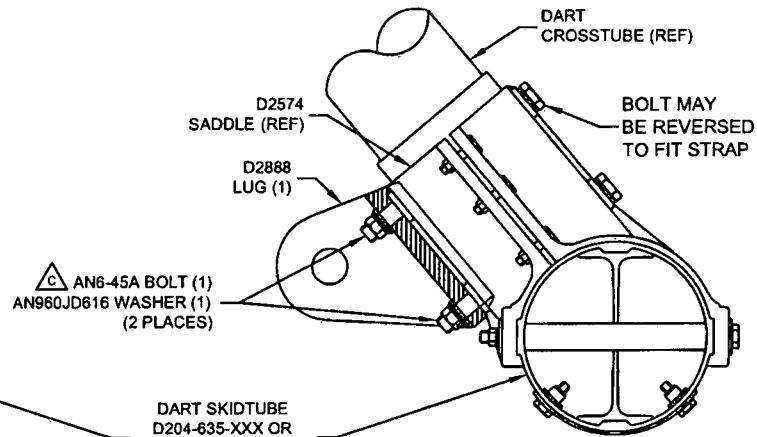
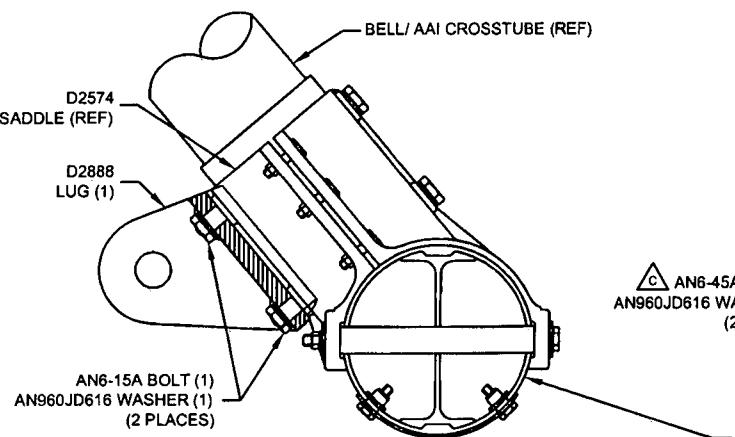


FIGURE 1
(BELL/AI CROSSTUBES)

FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION		
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D412-666	SHEET 1 OF 1
MFG. APPR.	N/A	TITLE	SCALE
APPROVED		412 GROSS WEIGHT TOWING KIT	1:4
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NO. 35318

